

Work Order ID 63687

November 16, 2010 10:19:36 AM



Page 1

Item ID: D4212-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 429 Clamp Cushion

Start Date: 11/10/10 Start Qty: 30.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4212

B

105

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL TO SIZE PER DRWG D4212 REV.B

10/11/18

30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10/11/18

30 *PTO*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subling

count
x30

*Qty Doesnt show Flat Pattern.
Length was told by MD it will
work.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4212-1 PAR #: CR10-29 Fault Category: Eng-drawing NCR: Yes ☐ No ☒ DQA: / Date: 10-11-30
 Resolution: accepted Disposition: use as is QA: N/C Closed: OK Date: 10/11/30

NCR: <u>63687</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/19	105	Dwg D4212 shows Dimension .17 AND DIM. .094 $\pm .000$ these are not critical, the bottom web is. The min should read .080	<u>10/11/19</u>	ACCEPTABLE ON THE BASIS THAT MANUFACTURING PROCESS WAS CHANGED FROM TURNED TO MILLED, DIMENSIONING WAS	<u>10/11/19</u>	<u>10/11/25</u>	<u>10/11/25</u>	
		D4212-1 <u>D63683</u>		NOT UPDATED ACCORDINGLY.				

NOTE: Date & initial all entries

Work Order ID 63687

November 16, 2010 10:19:36 AM

Page 2

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Required Date: 11/15/10 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125



Small Fab

Small Fab

Memo

FORM PER DRWG D4212 REV.B

0.00

0.00

SD 10/11/23

30

126



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

SD 10/11/24

counts
30

130



Packaging

Packaging

Identify as per dwg & Stock Location: 409

Memo

0.00

0.00

CC 10/14/25 (30)

Work Order ID 63687

November 16, 2010 10:19:37 AM

Page 3

Item ID: D4212-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 429 Clamp Cushion

Start Date: 11/10/10 Start Qty: 30.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

OK 10/11/25 MF

10-11-24

Picklist Print

November 16, 2010 10:19:35 AM

Page 1

Work Order ID: 63687

Parent Item: D4212-1

Parent Item Name: 429 Clamp Cushion



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	0.0000		0.3			



UHMW U-Channel

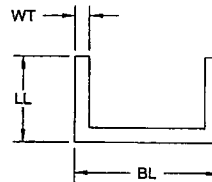


B63828

10/11/18

~~MA 4136 B 63682~~

SPECIFICATION CONTROL DRAWING



10 62687

D4287-X UHMW U-CHANNEL

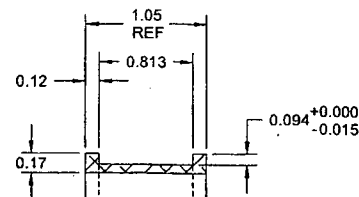
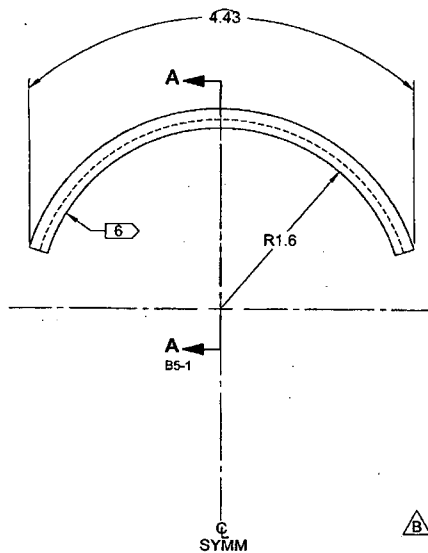
DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	PURCHASED LENGTH	BASE LENGTH (BL)	LEG LENGTH (LL)	WALL THICKNESS (WT)	WEIGHT (lbs)
D4287-1	McMASTER-CARR	9928K53	UHMW (WHITE)	96.0	1.05	0.75	0.250	2.11
D4287-3	McMASTER-CARR	8672K31	UHMW (WHITE)	96.0	1.25	0.75	0.125	1.29

RELEASED
2010-11-03

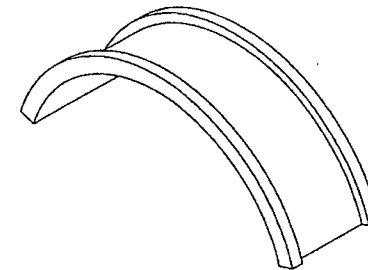
- NOTES:**
- 1) MATERIAL: PURCHASE PER TABLE
OR
UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMW
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: PER TABLE

A	NEW ISSUE	MB	10.10.26
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSC-D4287 TITLE UHMW U-CHANNEL SCALE NTS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.26		

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SECTION A-A B7-1



D4212-1 CLAMP CUSHION

NOTES:

- 1) MATERIAL: MAKE FROM D4287-1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "428 CLAMP CUSHION"; MATL WAS MUHMMWTR3.500W.X00XW (ZN A7-1)	MB	10.10.26
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4212** REV. B
SHEET 1 OF 1
TITLE **CLAMP CUSHION** SCALE NTS

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RELEASED
2010-11-03